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D4072-5

Job Sheet 197893



Part No: D4072-5

Job Qty: 24 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B SHEET 3 IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED BY:DD IPP REV:B DRAWING REV.
CHANGE AS PER ECN 11-598 11-07-05 JFS VERIFIED BY:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	24 pcs	7/30/19	7/30/19	0.03	1.68	Hardinge - 1		19/07/29
120	QC 8	24 pcs	7/30/19	7/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		B.A 19-07-29
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	24 pcs	7/30/19	7/30/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PC 51072
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	24 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21	21 JUL 30 2019
				QC 21 - SA - 70	9-09
				QC 21 - SA - 53	
Part Op 100 - (QC8- Inspect parts - second check) 1-Turn as per Dwg and Folio FA978 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M303R0.500	303 Round Bar 0.500"	.7200 ft (.03 ea)	100-Hardinge - 1	2150608	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M303R0.500	1	48	0	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.450Inches $\pm$ 0.030	0.480 0.420	Diameter	
2	Bushing	0.196Inches $\pm$ 0.005 - 0.001	0.201 0.195	Diameter	
3	Bushing	0.313Inches $\pm$ 0.010	0.323 0.303	Diameter	
4	Bushing	0.020Inches $\pm$ 0.100	0.120 (0.080)		
5	Bushing	45.000Degrees $\pm$ 0.500	45.500 44.500	Angle	
6	Bushing	0.230Inches $\pm$ 0.015 - 0.000	0.245 0.230		
7	Bushing	0.010Inches $\pm$ 0.030	0.040 (0.020)	Radius	
8	Bushing	0.060Inches $\pm$ 0.000 - 0.015	0.060 0.045		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐ Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐
Machining ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐
Large Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐

Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐ Contamination ☐ ☐ ☐
Bending ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐
Crushing ☐ ☐ ☐ BOM/Route ☐ ☐ ☐
Cracks ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐ Drill Holes ☐ ☐ ☐
Mislabeled ☐ ☐ ☐ Fit/Function ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐ Positioned Wrong ☐ ☐ ☐
Folio/Program ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐
Grain Direction ☐ ☐ ☐ Drawing ☐ ☐ ☐
Weld ☐ ☐ ☐ Finish ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐ Misread ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐

Other/Details: _____